

CLAIMS

1) A method for crimping electric contact (1) onto an electric wire (2), the contact having a crimping section (30) provided with a barrel (3) for receiving electric wire (2), the barrel comprising a part designed to clasp the wire by deformation, characterized in that it comprises a first crimping step at a first crimping height (h1) by folding a first surface of the crimping section over wire (2) by means of a crimping tool comprising a stamping element (6) and an anvil (7) and a second crimping step at a second crimping height (h2), lower than the first, in a localized region (4a, 4b, 4c, 5a, 5b, 5c) of the crimping section.

2) The method for crimping electric contact (1) according to claim 1, further characterized in that crimping section (30) has an open barrel (3) for receiving electric wire (2) and crimping wings (4, 5), those wings extending beyond the barrel and being designed to clasp the wire, and in that the first crimping step folds a first surface of wings (4, 5) at said first height (h1) onto wire (2) and the second crimping step folds a localized region (4a, 4b, 4c, 5a, 5b, 5c) of the wings at a second crimping height (h2), lower than the first.

3) The method according to claim 2, further characterized in that the second crimping is conducted over two disjoint zones (4b, 4c, 5b, 5c) of the wings.

4) The method according to claim 3, further characterized in that the second crimping is conducted over two end zones (4b, 4c, 5b, 5c) of the wings.

5) The method according to claim 2, further characterized in that the second crimping is conducted on a central zone (4a, 5a) of the wings.

6) The method according to one of the preceding claims, further characterized in that the first crimping step is conducted over the entire surface of wings (4, 5).

7) The method according to claim 6, further characterized in that the second crimping step is conducted over a part (4a, 4b, 4c, 5a, 5b, 5c) of the surface of the wings having undergone the first crimping step.

8 ) The method according to one of the preceding claims, further characterized in that the crimping tool has a common anvil (7) and separable stamping element parts (6a, 6b, 6c).

9) The method according to one of the preceding claims, further characterized in that barrel (3) is deformed during the first crimping step and keeps its form during the second crimping step.

10) An electric contact element comprising a crimping section (30) provided with an open barrel (3) equipped with wings (4, 5) for crimping onto an electric wire (2), said crimping section being crimped onto the wire by a method according to one of claims 1 to 9, characterized in that after crimping, crimping section (30) has three successive zones for crushing the wings onto the wire, two of the three zones being of reduced thickness with regard to the third zone so that the wire exerts an elastic force on the wings at the level of said third zone.

11) An electric contact element comprising a crimping section (30) provided with an open barrel (3) equipped with wings (4, 5) for crimping onto an electric wire (2), the crimping section being crimped onto the wire by a method according to one of claims 1 to 9, characterized in that after crimping, crimping section (30) has three successive zones for crushing the wings onto the wire, one of the three zones being

of reduced thickness with regard to the other two zones so that the wire exerts an elastic force on the wings at the level of said other two zones.